

Work Order ID 78050

December-28-11 9:04:19 AM

\*78050\*

Page 1

Item ID: D4092-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 12/28/11 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/28/11 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

Dep 29/12

EB 11/12/2012

EB 11/12/2012

8 11/12/2012

41

# Work Order ID 78050

**\*78050\***

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December-28-11 9:04:19 AM

Item ID: D4092-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Maintenance Step Assembly  
 Start Date: 12/28/11 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/28/11 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

M.L.J 11/12/29  
 (1)

# Picklist Print

December-28-11 9:04:18 AM

Page 1

Work Order ID: 78050

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 12/28/11

Required Date: 12/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD  
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	3.0000	2	2		12/29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST241A		3							
				74303		1							
				77189		2							
D4093-1 Bracket		Manufactured	No			100	Each	0.0000	1	1		12/29	
							B77853	(K)					
D4093-3 Bracket		Manufactured	No			100	Each	0.0000	1	1		12/29	
							B77850	(K)					
D4093-5 Bracket		Manufactured	No			100	Each	6.0000	2	2		12/29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST124		6							
				74998		6							
MS24694-S54 Screw		Purchased	No			100	Each	116.0000	2	2		12/29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST289A		116							
				118078		16							
				119124		100							
MS24694-S55 Screw		Purchased	No			100	Each	73.0000	8	8		12/29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST289A		73							
				119307		73							

# Picklist Print

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Page 2

Work Order ID: 78050

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 12/28/11

Required Date: 12/28/11

Start Qty: 1.00

Required Qty: 1.00

MS24694-S56  
SCREW

Purchased

No

100 Each 33.0000

2

2

Location

Loc Qty

Loc Code

ST289A

33

104407

33

NAS1149D0332J  
Washer

Purchased

No

100 Each 2,451.0000

12

12

Location

Loc Qty

Loc Code

ST298

2451

105793

12

110985

4

117087

89

118384

346

119042

1000

119717

1000

MS21042L3  
Nut

Purchased

No

100 Each 6,837.0000

12

12

Location

Loc Qty

Loc Code

ST300

6837

117441

16

117885

32

118451

5

118927

3

119017

5988

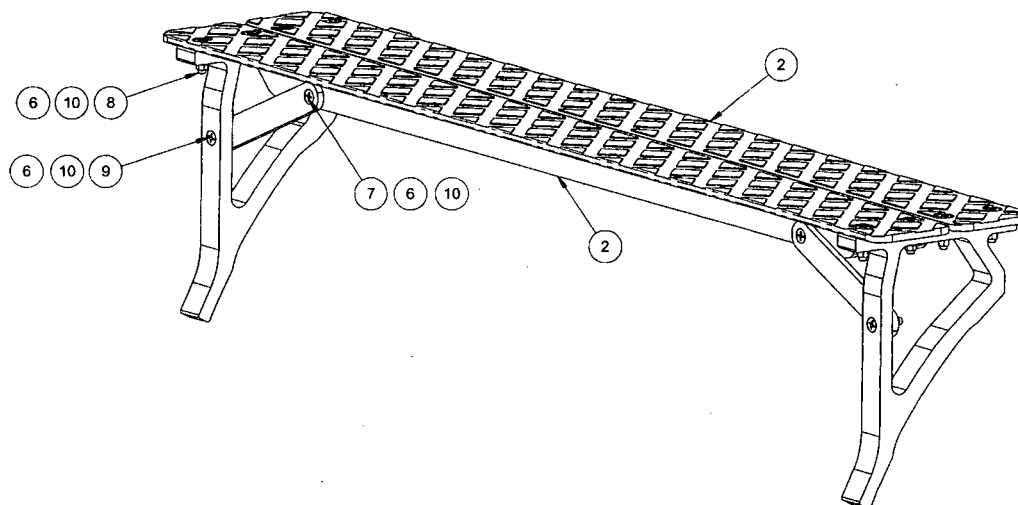
119075

793

December-28-11 9:04:18 AM

Shop Packet Print

Page 2



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

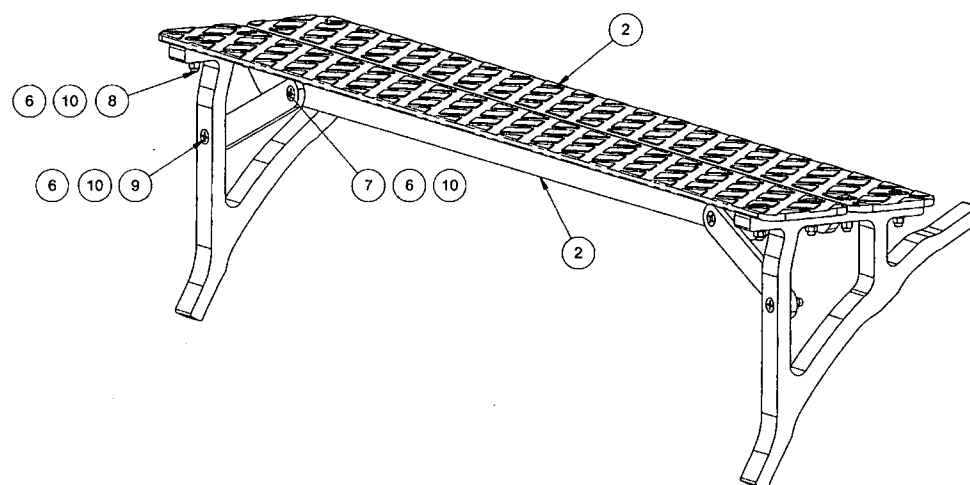
**D4092-041 MAINTENANCE STEP ASSEMBLY**



**RELEASED**  
2011-09-22  
WV

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 1 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASSY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

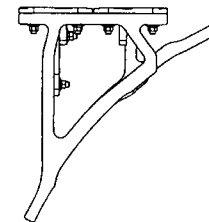
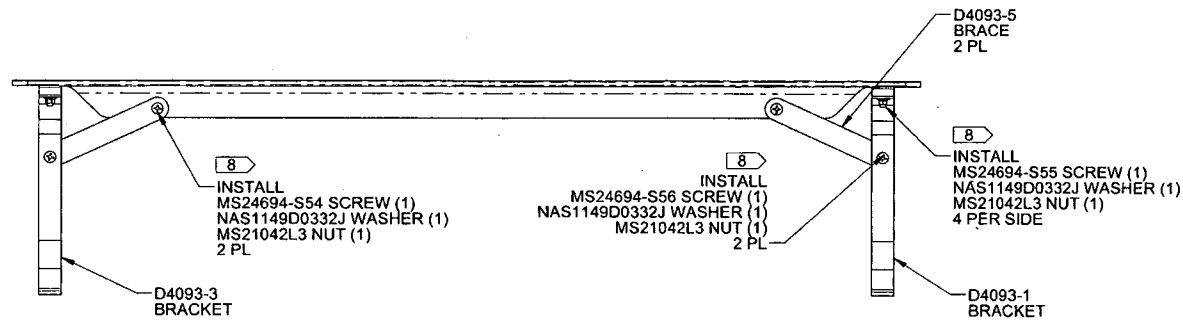
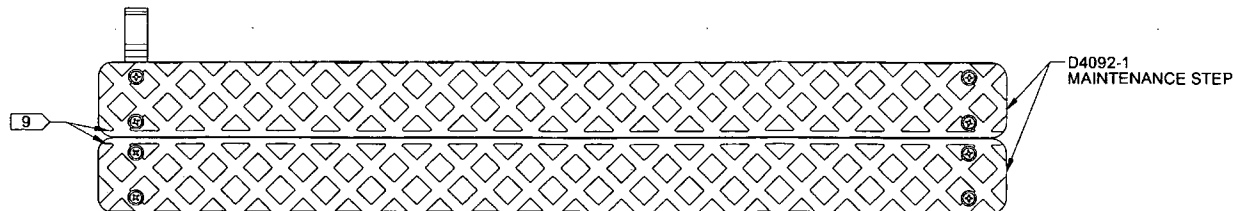


**D4092-042 MAINTENANCE STEP ASSEMBLY**



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MFG. APPR.	<i>21</i>	D4092	SHEET 2 OF 6
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DE APPR.	<i>14</i>	MAINTENANCE STEP ASS'Y	NTS
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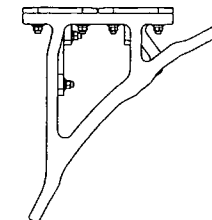
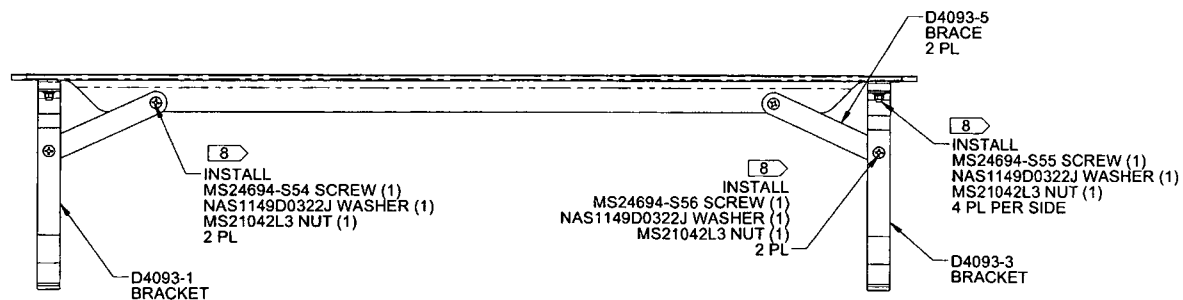
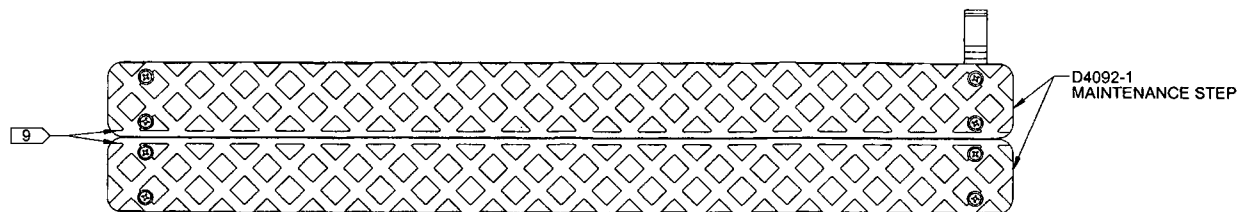
# **D4092-041 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 6.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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2011-09-22

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MFG. APPR.	21	<b>D4092</b>	SHEET 3 OF 6
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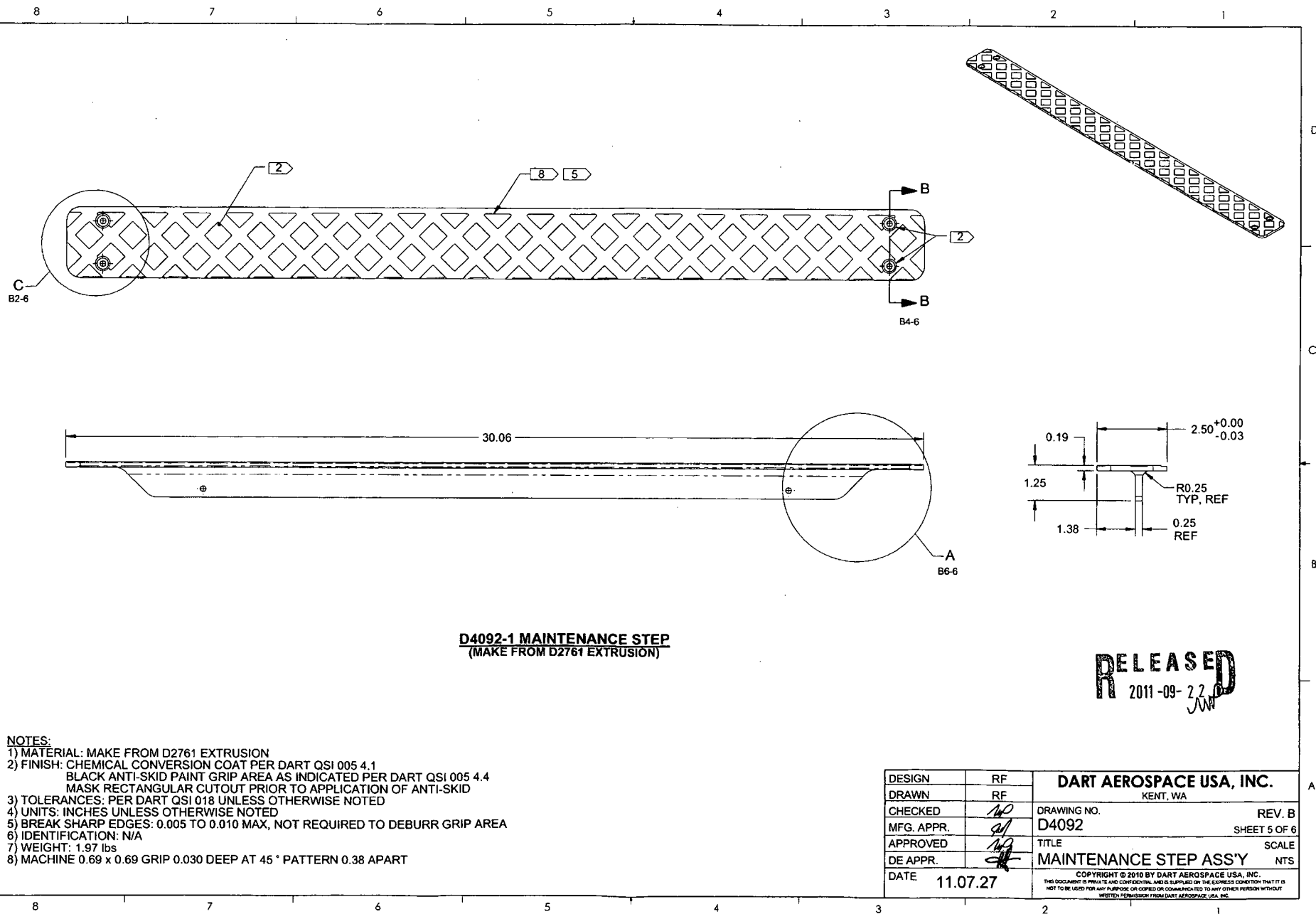
# **D4092-042 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	21	<b>D4092</b>	SHEET 4 OF 6
APPROVED	10	TITLE	SCALE
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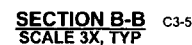
**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASSY</b>	NTS
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